

April 21, 2016 2:06:37 PM

Page 1

Accept

Setup Start

NS1

Item Name:	Step / Handle
------------	---------------

Stop

NS2

Start Date: 5/9/2016 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 5/23/2016 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: **Process Plan:** MLJ

Date: APR 22 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Work Order ID 144605

April 21, 2016 2:06:37 PM

144605

Page 2

Item ID: D4103-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Step / Handle

Start Date: 5/9/2016

Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/23/2016

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

10

0

DAS

20

9-89

16-05-12

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

10 x 4 all 16 loc 22

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

(10)

DAS

38

9-89

JUN 23 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Work Order ID 144605

144605

Page 3

April 21, 2016 2:06:37 PM

Item ID: D4103-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step / Handle
 Start Date: 5/9/2016 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 5/23/2016 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>ST080</u>	0.00						DAS	
160								21	JUN 24 2016
Packaging	Memo	0.00				10		9-89	
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

16/6/27 *[Signature]*
 em 16/06/24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

April 21, 2016 2:06:36 PM

Page 1

Work Order ID: 144605

144605

Parent Item: D4103-1

D4103-1

Parent Item Name: Step / Handle

Start Date: 5/9/2016

Required Date: 5/23/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV: A NEW ISSUE 10-07-01 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X03.50 0		Purchased	No			100	f	16.6300	0.52	5.473684			DAS

M6061T6B2 000X03 500

5.333'

DAS
20
9-89 1605-10

6061-T6 Bar 2.00 x 3.50

Location

Loc Qty

Loc Code

MAT004

16.63

m134057 /

16.63

5.333'

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order: 144605
Description: Step/Handle		Part Number: D4103-1
Inspection Dwg: D4103	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

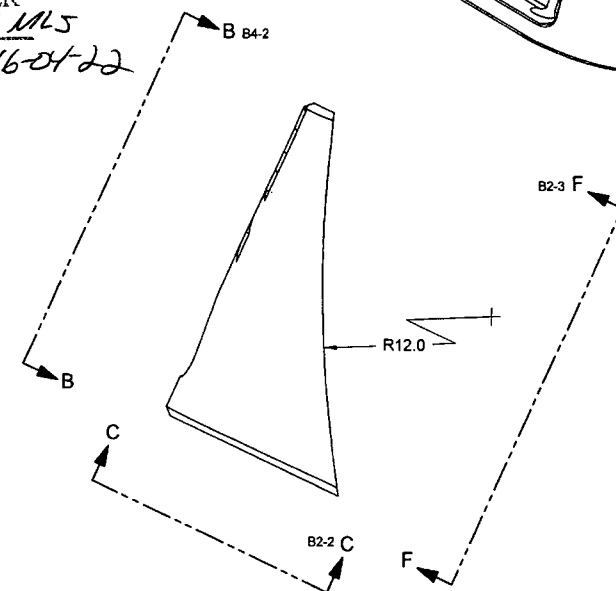
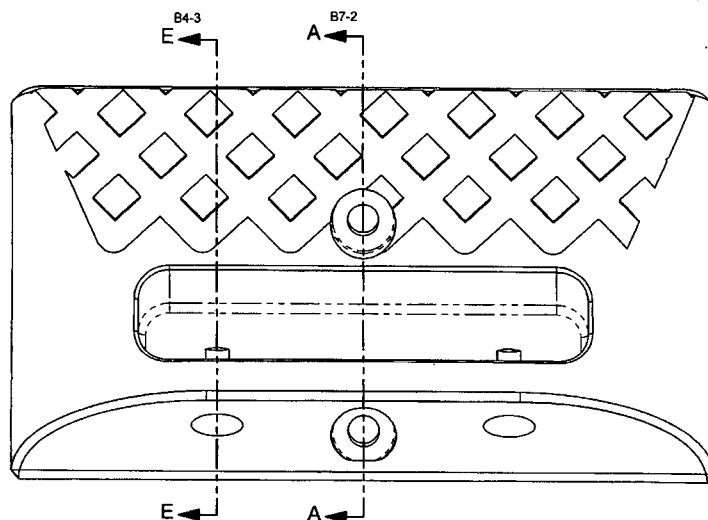
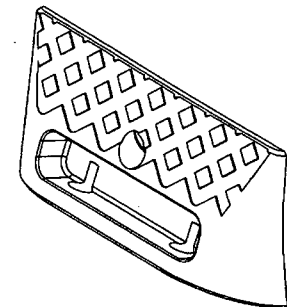
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.93	+/-0.030	2.932	/		Vern	FK-04
0.37	+/-0.030	.37	/			
0.83	+/-0.030	.83	/			
Ø0.560	+/-0.010	.56	/			
0.06 X 45°	+/-0.030 X +/-0.5°	.075 X 45°	/			
0.26	+/-0.030	.26	/			
0.33	+/-0.030	.333	/			
R0.06	+/-0.030	.0625	/		R-G.	
1.78	+/-0.030	1.784	/		Vern	FK-04
0.45	+/-0.030	.444	/			
0.33	+/-0.030	.333	/			
0.75	+0.000/-0.030	.75	/			
1.66	+/-0.030	1.647	/			
0.80	+/-0.030	.770	/			
1.07	+/-0.030	1.073	/		H-G.	31006
3.85	+/-0.030	3.851	/		Vern	FK-04
0.03 X 45°	+/-0.030 X +/-0.5°	.045 X 45°	/			
0.31	+/-0.030	.308	/			
0.28	+/-0.030	.28	/			
0.030 Deep	+/-0.030	.030	/			
6.00	+/-0.030	6.000	/			
R0.27	+/-0.030	.27	/		R-G.	
0.56	+/-0.030	.56	/		Vern	FK-04
1.74	+/-0.030	1.74	/			
2.50	+/-0.030	2.496	/			
Ø0.438	+0.006/-0.001	.438	/			
Ø0.266	+0.006/-0.001	.266	/			
0.96	+/-0.030	.953	/			
0.26	+/-0.030	.253	/			
0.25	+/-0.030	.246	/			
2.25	+/-0.030	2.250	/			
1.00	+/-0.030	1.00	/			
0.20	+/-0.030	.195	/			
0.98	+/-0.030	.98	/			
0.32	+/-0.030	.32	/			
1.25	+/-0.030	1.25	/			
R0.19	+/-0.030	.1875	/		R-G.	

Measured by: 44 9-89	Audited by: 20 9-89	Preliminary Approval:
Date: 16/05/11	Date: 16-05-12	Date:

Rev	Date	Change	Revised by	Approved
A	10.10.07	New Issue	KJ	

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 144605 ML5
16-04-22



D4103-1 STEP/HANDLE

NOTES:

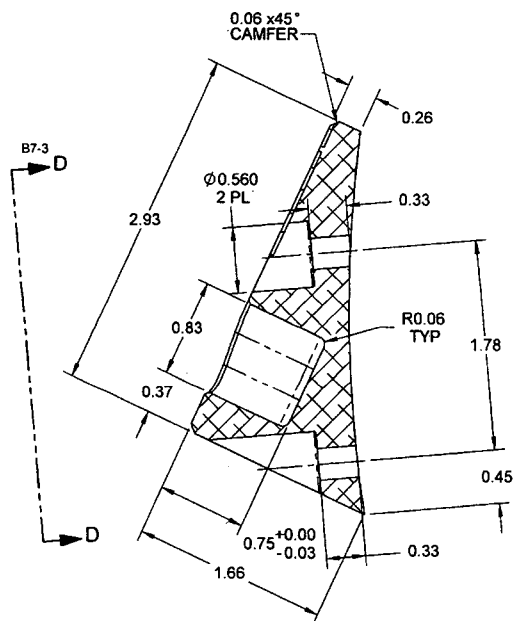
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4103-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.81 lbs
- 8) MACHINE 0.28 x 0.31 GRIP 0.030 DEEP AT 45° PATTERN 0.25 APART

RELEASED
R 2010-08-23
JND

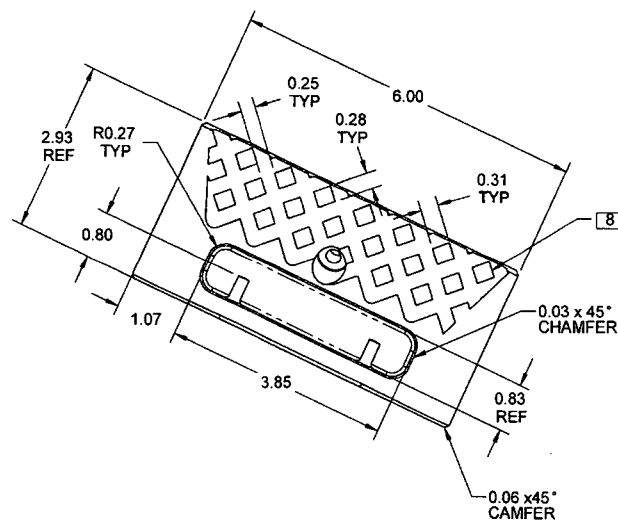
A		NEW ISSUE		RF	10.05.17
REV.		DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	RF				
CHECKED	RF	DRAWING NO.	REV. A		
MFG. APPR.	RF	D4103	SHEET 1 OF 3		
APPROVED	RF	TITLE	SCALE		
DE APPR.	RF	STEP/HANDLE	NTS		
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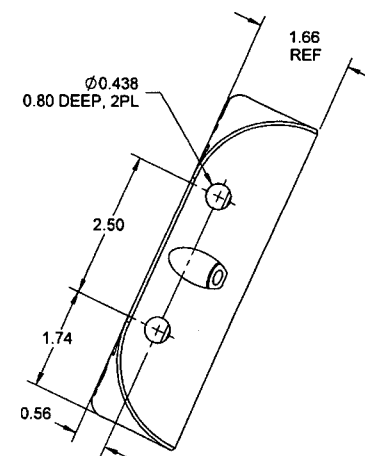
D
C
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SECTION A-A D6-1



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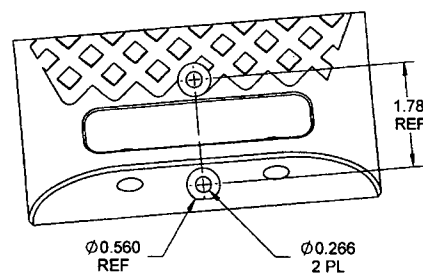


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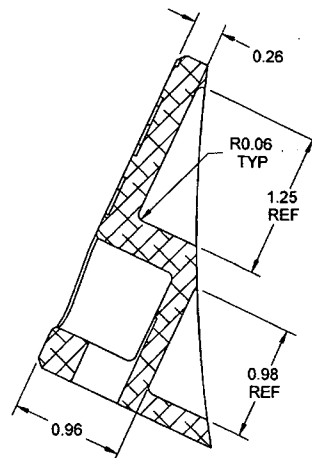
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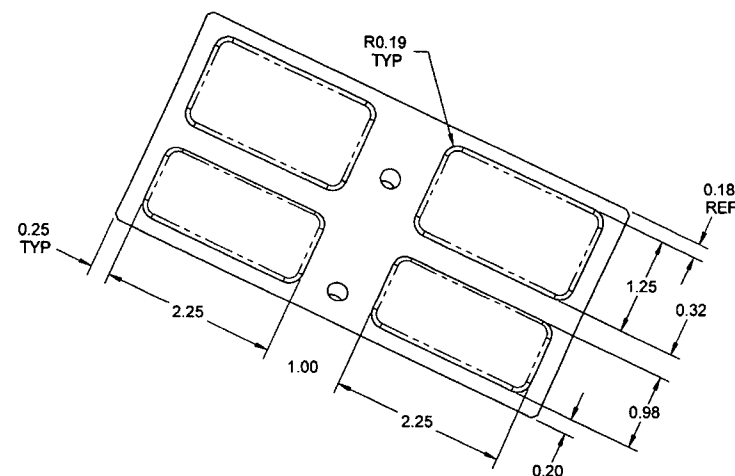
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VIEW D-D C8-2
SCALE 0.5X



VIEW E-E D7-1



VIEW F-F C1-1

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